

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004354**Date Inspected:** 06-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

The Quality Assurance (QA) Inspector Gregory Bertlesman arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following.

**East Shaft Lift 1**

The Quality Assurance Inspector observed ZPMC continuing to tack weld several diaphragm plates to skin A utilizing the shielded metal arc welding process.

**South Shaft Lift 1**

The Quality Assurance Inspector observed ZPMC erecting the 23M Diaphragm and the 28M Diaphragm on to the South Shaft Assembly.

**Green Tag Log**

The Quality Assurance Inspector developed a system in an effort to track tower sub assembly components that have been "green tagged" with American Bridge/Fluor's internal green tag procedure. The spreadsheet was placed in the internal server in an effort to have all Caltrans Quality Assurance Inspectors and Structures Representatives to have access to. The log will be updated as sub assemblies are completed.

**Summary of Conversations:**

As stated in the contents of the above report.

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## WELDING INSPECTION REPORT

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi 137.6471.0411 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Bertlesman,Greg
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Wright,Mark
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QA Reviewer
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